



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3912-5
Job Sheet 174862



Part No: D3912-5

Job Qty: 30 ea

Part Name: Eyebolt Plate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/22/18

Job Tracking No:

Due Date: 3/29/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV B IPP RevA: new issue DD 09.11.17 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	30 Ea		3/28/18	0.00	0.00	Start Up Waterjet		SC 18/03/18
100	Waterjet	30 pcs		3/29/18	0.04	1.80	Waterjet1		SC 18/03/18
120	QC	30 pcs		3/29/18	0.00	0.00	QC8		SC 18/03/18
130	Packaging	30 pcs		3/29/18	0.00	0.00	Packaging3	58056	APR 01 2018
140	QC21-SA	30 Ea		3/29/18	0.00	0.00	QC21		DAS 21 9-20 APR 02 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S11GA	304/316 0.125 Sheet	1.5375 sf (.05125 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S11GA	2	131	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Water Jet ☐ Prod. Eng. Coord. ☐ Engineering ☐ Quality ☐ Other ☐	
Date : _____		Step #: _____		Container No: S055696 Part: D3912-5 Job No: 174862 Serial No/Batch: S055696 Revision: _____ Inspector: _____ Date: 03/27/18		B (QSI042) Approval _____			
Description Work Order Dev _____						Completed By _____			
						I hand / Supervisor approval Verification _____			
Root Cause									
Environment	☐	No Re-verification	☐	Pressure	☐	Conditioned Wrong	☐	Outside Dimensions	☐
Design	☐	Operator	☐	Bending	☐	Over/Under tolerance	☐	Part Incorrect	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not concentric	☐	Part Lost/Missing	☐	Part Moved	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Drawing	☐	Finish	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Misread	☐	Misaligned/off center	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Turning Sequence	☐		
Internal Transport	☐	Poor Information	☐	Crushing	☐				
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐				
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐				
Substation	☐	Process Improvement	☐	Marks/Chatter	☐				
Past Expiry Date	☐	Manufacturing Process	☐						
Misidentified	☐	Past Due	☐	OTHER :					

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Eyebolt Plate	0.129Inches + 0.005 - 0.001	0.134 0.128	0,130	Diameter
2	Eyebolt Plate	0.257Inches + 0.006 - 0.001	0.263 0.256	0,258	Diameter
3	Eyebolt Plate	0.380Inches + 0.030 - 0.003	0.410 0.377	0,383	
4	Eyebolt Plate	1.500Inches ± 0.010	1.510 1.490	1,502	
5	Eyebolt Plate	0.500Inches ± 0.010	0.510 0.490	0,501	Pitch
6	Eyebolt Plate	3.150Inches ± 0.030	3.180 3.120	3,154	
7	Eyebolt Plate	0.375Inches ± 0.010	0.385 0.365	0,378	
8	Eyebolt Plate	0.517Inches ± 0.010	0.527 0.507	0,520	
9	Eyebolt Plate	1.000Inches ± 0.010	1.010 0.990	1,001	
10	Eyebolt Plate	3.650Inches ± 0.030	3.680 3.620	3,653	
11	Eyebolt Plate	1.500Inches + 0.020 - 0.000	1.520 1.500	1,500	
12	Eyebolt Plate	0.250Inches ± 0.030	0.280 0.220	0,252	
13	Eyebolt Plate	2.000Inches ± 0.030	2.030 1.970	2,001	
14	Eyebolt Plate	0.125Inches ± 0.010	0.135 0.115	0,115	

Plex 3/22/18 11:28 AM dart.lacelle.linda

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																																																																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																																																																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																																																																		
Large Fab ☐	Composite ☐	Supplier ☐																																																																			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																																																																	
Description Work Order Deviation			Disposition																																																																		
			Completed By																																																																		
			Lead hand / Supervisor Approval Verification																																																																		
			QC / QA Coordinator Approval																																																																		
Root Cause <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Environment ☐</td> <td style="border: none;">No Re-verification ☐</td> </tr> <tr> <td style="border: none;">Design ☐</td> <td style="border: none;">Operator ☐</td> </tr> <tr> <td style="border: none;">Doc/Data ☐</td> <td style="border: none;">Offset/Setup ☐</td> </tr> <tr> <td style="border: none;">Equip/Tooling ☐</td> <td style="border: none;">Supplier ☐</td> </tr> <tr> <td style="border: none;">Handling/Pre ☐</td> <td style="border: none;">Training ☐</td> </tr> <tr> <td style="border: none;">Material ☐</td> <td style="border: none;">Use for Testing ☐</td> </tr> <tr> <td style="border: none;">Internal Transport ☐</td> <td style="border: none;">Poor Information ☐</td> </tr> <tr> <td style="border: none;">Tribal Knowledge ☐</td> <td style="border: none;">Rushing ☐</td> </tr> <tr> <td style="border: none;">LOA ☐</td> <td style="border: none;">Product Improvement ☐</td> </tr> <tr> <td style="border: none;">Substation ☐</td> <td style="border: none;">Process Improvement ☐</td> </tr> <tr> <td style="border: none;">Past Expiry Date ☐</td> <td style="border: none;">Manufacturing Process ☐</td> </tr> <tr> <td style="border: none;">Misidentified ☐</td> <td style="border: none;">Past Due ☐</td> </tr> </table>		Environment ☐	No Re-verification ☐	Design ☐	Operator ☐	Doc/Data ☐	Offset/Setup ☐	Equip/Tooling ☐	Supplier ☐	Handling/Pre ☐	Training ☐	Material ☐	Use for Testing ☐	Internal Transport ☐	Poor Information ☐	Tribal Knowledge ☐	Rushing ☐	LOA ☐	Product Improvement ☐	Substation ☐	Process Improvement ☐	Past Expiry Date ☐	Manufacturing Process ☐	Misidentified ☐	Past Due ☐	FAULT CATEGORY <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Pressure/Forced ☐</td> <td style="border: none;">Temperature/Cure ☐</td> <td style="border: none;">Power Loss/Surge ☐</td> <td style="border: none;">Positioned Wrong ☐</td> </tr> <tr> <td style="border: none;">Bending ☐</td> <td style="border: none;">Set-up ☐</td> <td style="border: none;">Folio/Program ☐</td> <td style="border: none;">Outside Dimensions ☐</td> </tr> <tr> <td style="border: none;">Centre Not Concentric ☐</td> <td style="border: none;">BOM/Route ☐</td> <td style="border: none;">Grain ☐</td> <td style="border: none;">Over/Under tolerance ☐</td> </tr> <tr> <td style="border: none;">Cracks ☐</td> <td style="border: none;">Broken/Damage/Defect ☐</td> <td style="border: none;">Weld ☐</td> <td style="border: none;">Part Incorrect ☐</td> </tr> <tr> <td style="border: none;">Crimp/Kink/Ripple/Wave ☐</td> <td style="border: none;">Inspection Incomplete/Unqualified ☐</td> <td style="border: none;">Wrong Stock Pulled ☐</td> <td style="border: none;">Part Lost/Missing ☐</td> </tr> <tr> <td style="border: none;">Cuffs ☐</td> <td style="border: none;">Contamination ☐</td> <td style="border: none;">Out of Sequence ☐</td> <td style="border: none;">Part Moved ☐</td> </tr> <tr> <td style="border: none;">Crushing ☐</td> <td style="border: none;">Countersink ☐</td> <td style="border: none;">Off-set ☐</td> <td style="border: none;">Drawing ☐</td> </tr> <tr> <td style="border: none;">Heat Treat ☐</td> <td style="border: none;">Cut Too Short ☐</td> <td style="border: none;">Mislabeled ☐</td> <td style="border: none;">Finish ☐</td> </tr> <tr> <td style="border: none;">Wave/Twist in Tube ☐</td> <td style="border: none;">Instructions Incomplete/Unclear ☐</td> <td style="border: none;">Fit/Function ☐</td> <td style="border: none;">Misread ☐</td> </tr> <tr> <td style="border: none;">Marks/Chatter ☐</td> <td style="border: none;">Drill Holes ☐</td> <td style="border: none;">Misaligned/off center ☐</td> <td style="border: none;">Turning Sequence ☐</td> </tr> </table>				Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Environment ☐	No Re-verification ☐																																																																				
Design ☐	Operator ☐																																																																				
Doc/Data ☐	Offset/Setup ☐																																																																				
Equip/Tooling ☐	Supplier ☐																																																																				
Handling/Pre ☐	Training ☐																																																																				
Material ☐	Use for Testing ☐																																																																				
Internal Transport ☐	Poor Information ☐																																																																				
Tribal Knowledge ☐	Rushing ☐																																																																				
LOA ☐	Product Improvement ☐																																																																				
Substation ☐	Process Improvement ☐																																																																				
Past Expiry Date ☐	Manufacturing Process ☐																																																																				
Misidentified ☐	Past Due ☐																																																																				
Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																																																																		
Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																																																																		
Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																																																																		
Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																																																																		
Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																																																																		
Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																																																																		
Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																																																																		
Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																																																																		
Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																																																																		
Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																																																																		
OTHER :																																																																					